

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009304**Date Inspected:** 21-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen fu you**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

FCAW welding of weld joint 1G-020 located on PCMK SEG055A of 9DW welder is identified as 066401.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

SAW welding of weld joint 1G-006 located on PCMK SEG051*-006 of 9BW welder is identified as 045265. ZPMC QC is identified as Mr.Liu wan ning. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

FCAW welding of weld joint 3F-019 located on PCMK DP99-001 of 9EW welder is identified as 0207465.ZPMC QC is identified as Mr.Liu wan ning. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133.

FCAW welding on ongoing repair welding due to root gap 11mm of weld joint SSD12-PP82-133 Of 9DW welder is identified as 066401.ZPMC QC is identified as Mr.Li ming yang. In this ZPMC Using backing bar, it is found that there is 3mm gap in between backing bar and weld joint. ZPMC started their welding. WPS-B-T-2233-B-U2a-FCM-F and WR7340. It is informed to

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

ZPMC QC Mr.Li ming yang and ABF QA Mr.Liu jin ping.

Ongoing heat straightening of Deck panel splice weld SEG059*-005,006 ,008 & 009 Flatness, temperature Checked with ZPMC QC Mr.Liu wan ning and the variables recorded as per report.

The following fillet weld joints having more than 5mm root gap, of segment 10CW -5nos side plate stiffeners which is connecting the CSD the weld nos are SP678-001-011 to 015 informed to ZPMC QC Mr.Li ming yang.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Item	Description	WBS	Dwg No.	Status
1				
2				

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer